

Work Order ID 128239

Tuesday, January 13, 2015 1:33:14 PM

128239

Page 1

Item ID: D3794-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket Aft
 Start Date: 1/13/2015 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 1/20/2015 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-01-14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3794	Rev A

100 FLOW WATER JET 0.00
100 Waterjet Memo 0.00 24 Ø Jm 15-2-1
 FLOW CNC Waterjet 1-Cut as per Dwg D3794 Dwg Rev: A Prog Rev: A 2-
 Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110 QC Memo 0.00 24 Ø Jm 15-2-1
 Quality Control

120 QC8- Inspect parts - second check 0.00
120 QC Memo 0.00 24 Ø Jm 15-2-1
 Quality Control

DAS
38
9-89
FEB 03 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other	
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>FP-001</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

x24 ✓ HL 15/02/07

MLJ 1502-04

MS-3

DQA: _____ Date: _____



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Picklist Print

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Work Order ID: 128239

128239

Parent Item: D3794-3

D3794-3

Parent Item Name: Gasket Aft

Start Date: 1/13/2015

Required Date: 1/20/2015

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MNEO60S.063

Purchased

No

100

sf

347.6670

1.2828

(23)

MNEO60S 063

Jm15-2-1

NEOPRENE SHEET 0.063

Location

Loc Qty

Loc Code

MAT052

347.667

M130840

347.667

130840.

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DART AEROSPACE LTD		Work Order: 128239
Description: Gasket		Part Number: D3794-3
Inspection Dwg: D3794	Rev: A	Page 1 of 1

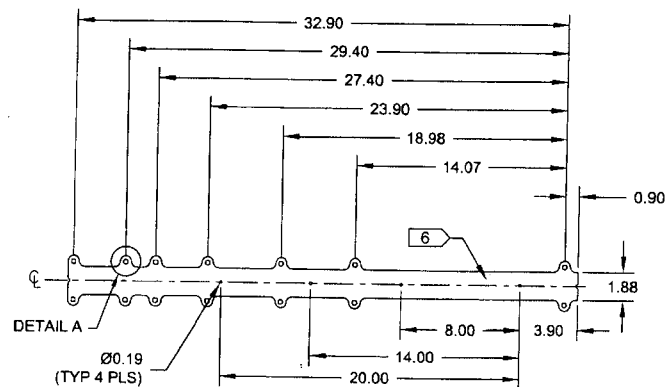
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

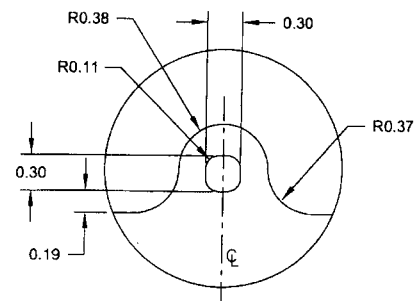
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	0.19"	-		V	Jkmo
0.300 x 0.300	+/-0.010	0.300 x 0.300	-		V	
1.88	+/-0.030	1.88"	-		V	
4.281	+/-0.010	4.281"	-		V	
6.44	+/-0.030	6.44"	-		V	
6.00	+/-0.030	6.00"	-		V	
6.75	+/-0.030	6.75"	-		V	
2.00	+/-0.030	2.00"	-		V	
4.75	+/-0.030	4.75"	-		V	
9.50	+/-0.030	9.50"	-		T	Jkmo
14.25	+/-0.030	14.25"	-		T	
17.75	+/-0.030	17.75"	-		T	
26.74	+/-0.030	26.74"	-		T	
29.23	+/-0.030	29.23"	-		T	

Measured by: JM	Audited by: DAS 38	Prototype Approval:	N/A
Date: 15-2-1	Date: FEB 03 2015	Date:	N/A

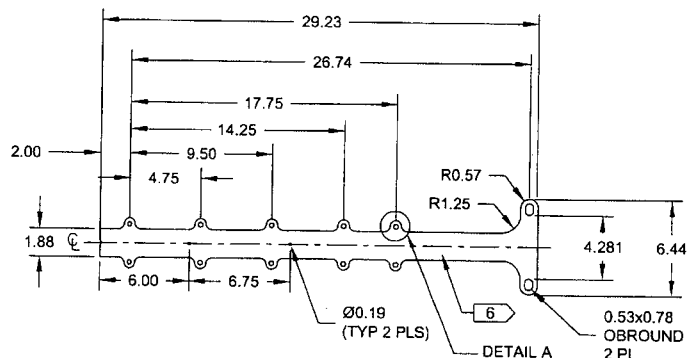
Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DD	
B	08.10.17	17.75 revised per Dwg Rev. A	KJ/DD	



D3794-1 GASKET



DETAIL A
SCALE 8X



D3794-3 GASKET

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 128239 MLO
1501-14

RELEASED
08-05-14

A	NEW ISSUE		PH	08.05.14
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC		
DRAWN	PH	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3794	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		GASKET	NTS	
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC		
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